

Date: Thursday, 2/22/2007 2:57:30 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 30812		
Estimate Number	: 10299		
P.O. Number	: <i>N/A</i>	Part Number	: D25775
This Issue	: 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2577 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: E
Previous Run	: 28639	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/15/2007
Checked & Approved By	: <i>JA 07.02.23</i>	Qty:	<i>39</i> / 30 Um: Each
Comment	: Est: P 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 1.0301 sf(s)/Unit Total : 30.9015 sf(s)

1010/1025 16GA SHEET

(m1010s16ga)

Batch: *421**M104000A (3)**SAD**07/05/14*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2577

Dwg Rev: *E*Prog Rev: *E**SAD 07/05/14**(34)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

*SAD 07/05/14**(34)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07-05-15 (34)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

07/05/22 (34)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PR Date: 07/05/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:57:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30812

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

JB 07/05/25

(34)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAOS 28

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601

BR/M-L 07/05/29

(34)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/05/30

(34)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

a.m 07/05/30

(34)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/31

(31)

Job Completion



U 07/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
00.09.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

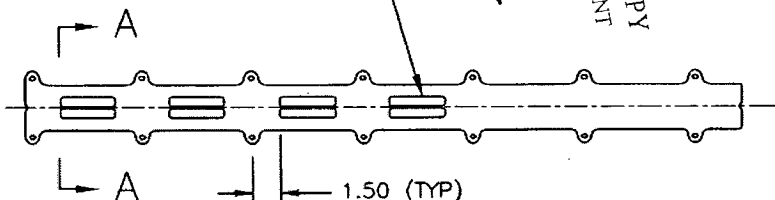
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



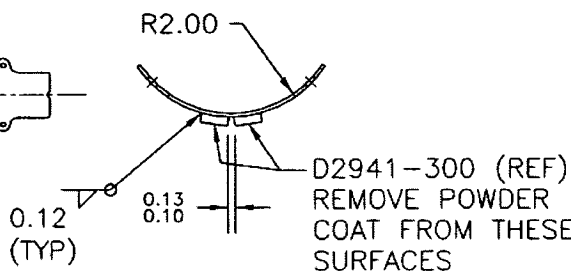
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30812

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



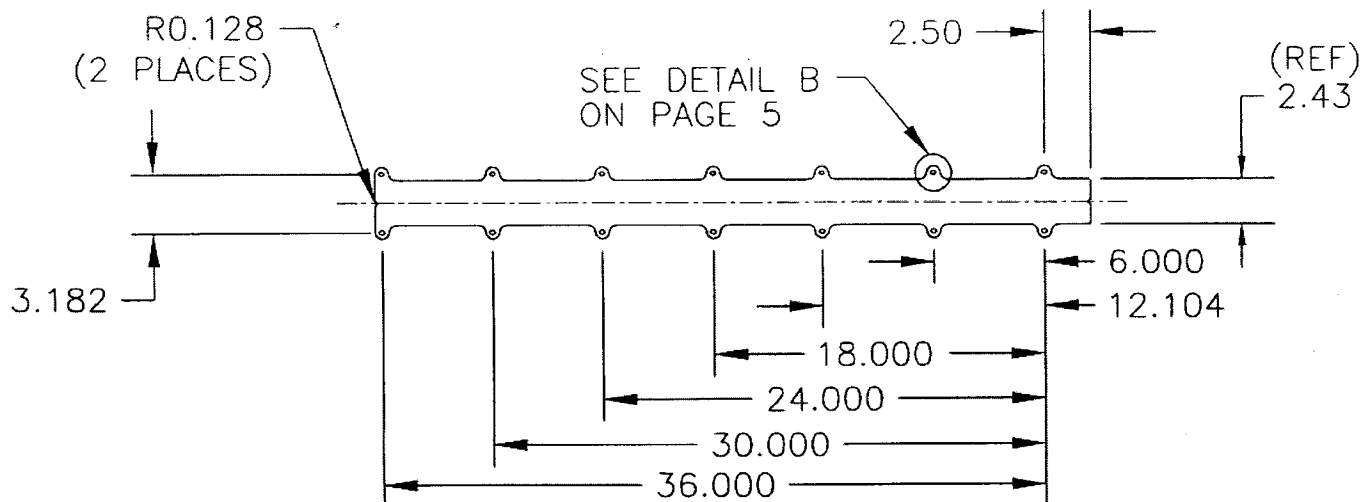
SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 2 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10



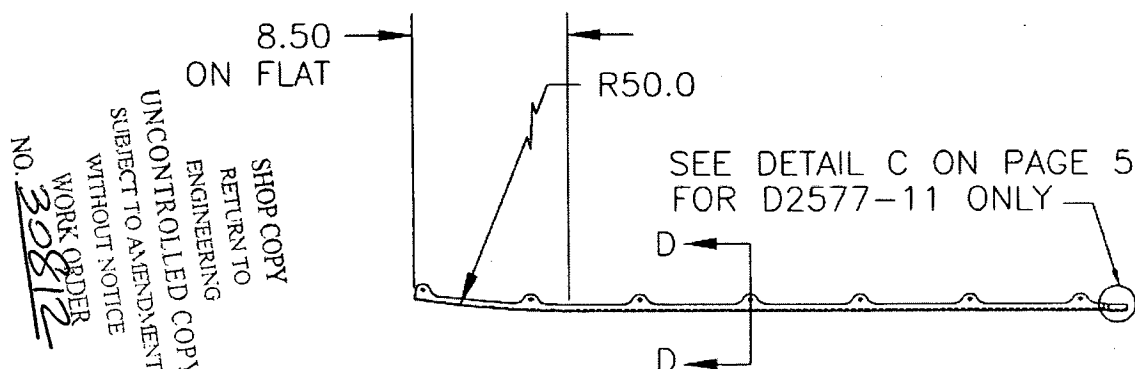
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30812



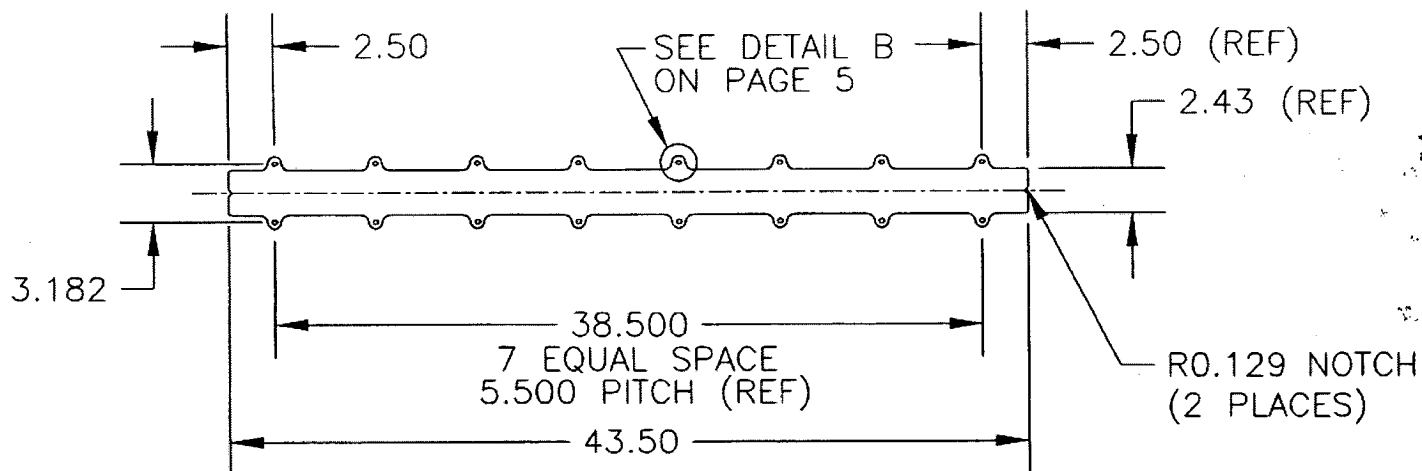
DART



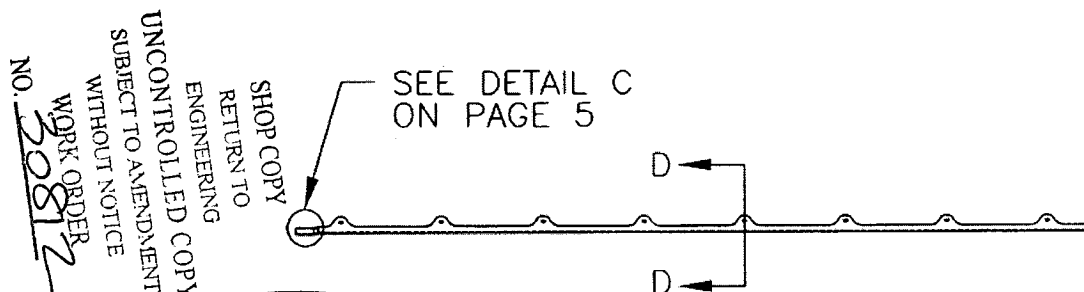
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22	TITLE WEARSHOE	REV. E SHEET 3 OF 5
	SCALE 1:10	

RELEASED
00.07.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

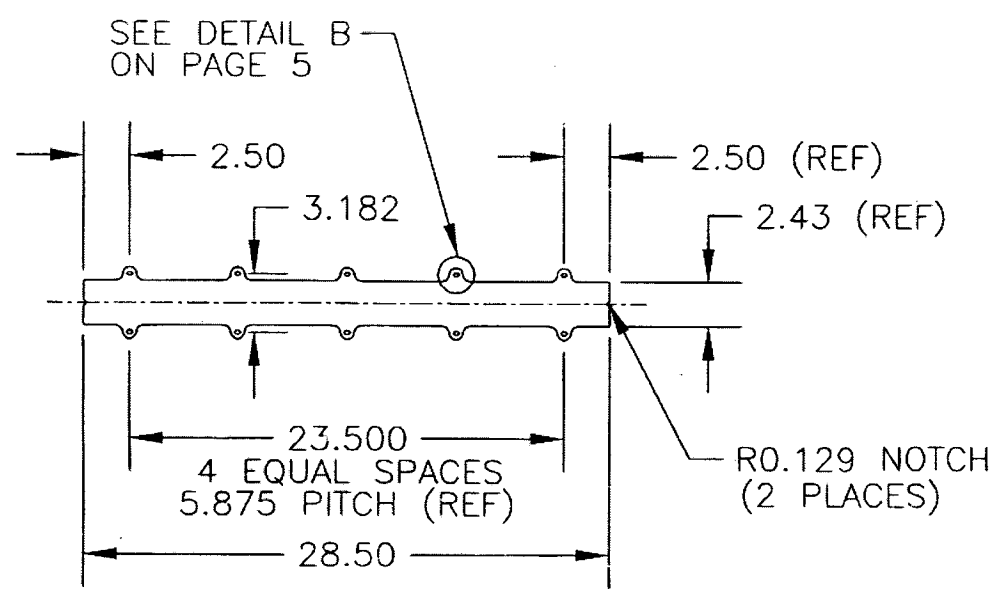
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



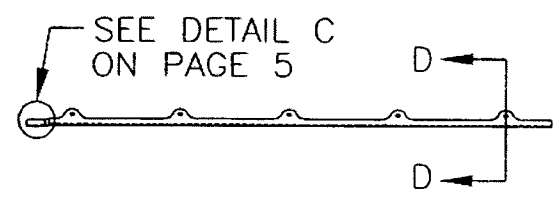
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	DRAWING NO.
00.09.22	WEARSHOE	D2577
		SHEET 4 OF 5
	SCALE	REV. E
	1:10	

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30812

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

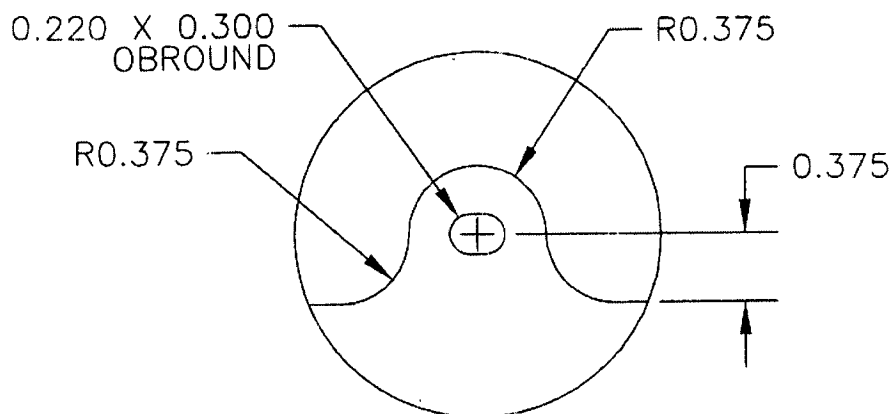
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



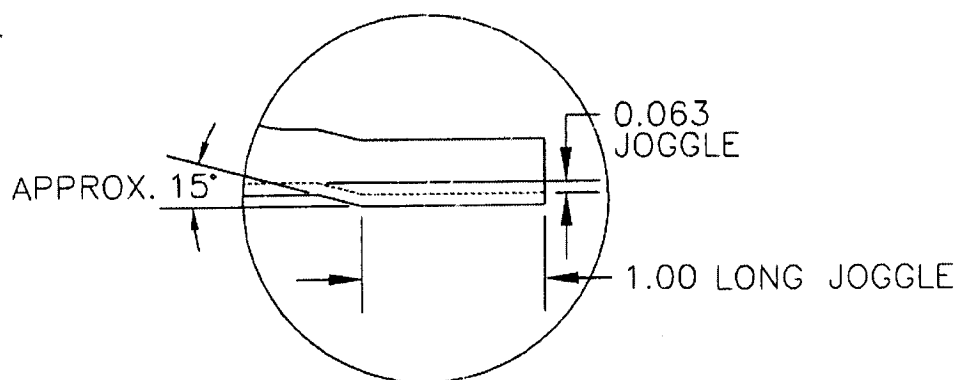
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)

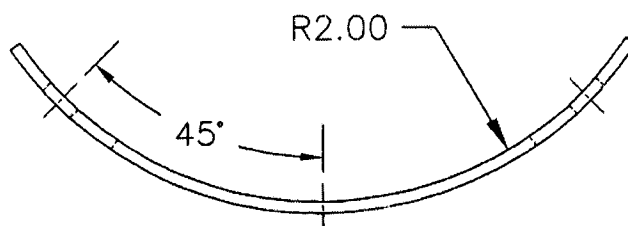
RELEASED
00.09.26



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30812

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

